

Work Order ID 160123

Friday, April 21, 2017 11:47:14 AM

160123

Page 1

Item ID: D3802-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Window Seal (\$ per foot) **50** **50** **APR 25 2017** **DAS** **13** **9-89**
Start Date: 4/24/2017 Start Qty: 25.00 ***25***
Required Date: 5/8/2017 Req'd Qty: 25.00 ***25*** Cust Item ID:
Reference: SCHEDULED Customer:

Approvals: Process Plan: **DAS** **21** **9-89** Date: **APR 21 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3802	D

100

100

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: **36069**

Purchase Part Number: 93695K58

Supplier: Mc MASTER-CARR

Certificate of conformity is required

0.00

0.00

50 **APR 25 2017** **DAS** **13** **9-89**

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

Ensure material certification is attached

0.00

0.50

50 **SP17-427**

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

Ensure Material certification comply to Dwg D3802

0.00

0.00

50 **MAY 01 2017** **DAS** **38** **9-89**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Page 2

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Start Date: 4/24/2017 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 5/8/2017 Req'd Qty: 25.00 ***25*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 51410	0.00							
130									
Packaging	Memo	0.25							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	2.50							
Quality Control									

SO' MAY 02 2017

17/5/4

DAS 21 9-89 MAY 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Friday, April 21, 2017 11:47:17 AM

Page 1

Work Order ID: 160123

160123

Parent Item: D3802-1

D3802-1

Parent Item Name: Window Seal (\$ per foot)

Start Date: 4/24/2017

Required Date: 5/8/2017

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A 09-01-12 rev.A as per dwg DD verified by:ec
IPP Rev:B 09-04-15 rev.b as per dwg DD verified by:EC IPP Rev:C
10.08.04 p/n chg per ECN10-568 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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93695K58

Purchased

No

110

f

0.0000

1

25

93695K58

WINDOW SEAL

50
50 8077437

DQA: _____ Date: _____



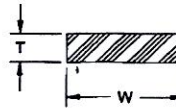
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

SPECIFICATION CONTROL DRAWING



D3802-X-YYY WINDOW SEAL
WHERE YYY REPRESENTS LENGTH

DART P/N	SUPPLIER	SUPPLIER P/N	T' THICKNESS	"W" WIDTH
D3802-1-YYY	McMASTER-CARR	93695K58	0.25	1.00

EG: 0.25" X 1.00" X 40" WINDOW SEAL = D3802-1-040
0.25" X 1.00" X 120" WINDOW SEAL = D3802-1-120

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160123MJS
1704-21

RELEASED
2011-11-25

NOTES:

- 1) MATERIAL: 'PEEL AND STICK' NEOPRENE/EPT/SBR BLEND CLOSED CELL SPONGE, MEDIUM DENSITY
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

D	CORRECTED P/N EXAMPLE FOR CUT LENGTH OF 40"; ADDED EXAMPLE FOR CUT LENGTH OF 120" ZN B3-1); REASON: PART11-100.	MB	11.11.22
C	CHANGE SUPPLIER P/N TO 93695K58 PER FLAMMABILITY TEST RESULTS	MB	10.06.30
B	CHANGE SUPPLIER P/N TO 93695K58 PER FLAMMABILITY TEST RESULTS	MB	08.12.18
A	NEW ISSUE	MB	08.06.20
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.11.22		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3802 REV. D SHEET 1 OF 1 TITLE WINDOW SEAL SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :									



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36069**

Purchase Order Date 4/25/2017

PO Print Date 4/25/2017

Page Number 2 of 8

Order From :

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

330 995 5500

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Purolator ground ppd

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

USD

FCA - (Free Carrier)

3	9776K117	Flame Retardent Nylon Hook & Loop	4/27/2017 Yes 4/27/2017	200.00 f	\$1.36	\$271.88
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AS PER DWG D3800 REV. B
B159766

Line Total: \$271.88

4	95606A170	Washer	4/27/2017 Yes 4/27/2017	100.00 Each	\$0.09	\$8.60
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AS PER DWG D3631 REV. A
B160124

Line Total: \$8.60

5	93695K58	WINDOW SEAL	4/27/2017 Yes 4/27/2017	50.00 / f	\$0.32	\$16.15
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AS PER DWG D3802 REV. D
B160123

Line Total:

\$16.15

DAS
38
9-89

Note:

4/25/2017



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO36069
Order Placed By
Chantal Lavoie

McMaster-Carr Number
2390118-04

Page 1 of 2
04/25/2017

Line	Product	Ordered	Shipped
1	90130A030 Weather-Resistant EPDM Rubber Sealing Washer for 5/16" Screw Size, 0.29" ID, 0.562" OD, Packs of 100	10 Packs	10
4	95606A170 Nylon Plastic Washer for 7/16" Screw Size, 0.5" ID, 0.689" OD, Off-White, Packs of 100	1 Pack	1
5	93695K58 Oil-Resistant Fire-Retardant Blended Buna-N Foam 50 Feet Adhesive-Back Strip, 1/4" Thick, 1" Wide	1 Each	1
6	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End 3/8"-24 RH Male Shank, 3/8" Ball ID, 1-1/4" Long Thread	15 Each	15
7	50715K676 Type 316 Stainless Steel 37 Degree Flared Tube Fitting Adapter for 1/4" Tube OD x 7/16"-20 UNF Male	16 Each	16
8	6541K38 Vibration-Resistant Zinc-Plated Steel Double Pinch Clamps 31/64" to 19/32" ID, for Firm Hose and Tube, Packs of 25	1 Pack	1
9	6519T14 Ultra-Chemical-Resistant Versilon PVC Tubing 3/8" ID, 9/16" OD	16 Feet	16
10	46595A36 Backup Pad for Hook and Loop Disc for 5" Disc Diameter, 5/16"-24 Threaded Spindle, Deliver To Carl	1 Each	1
11	2584A33 General Purpose Left-Hand Tap for Through-Hole Threading, 1/4"-28 Thread Size, Deliver To Eric L	1 Each	1
12	2600A16 General Purpose Die UNF Left-Hand Thread, 1" OD, 1/4"-28 Thread Size, Deliver To Eric L	1 Each	1
13	4168A611 High Performance Sanding Belt for Stainless Steel and Hard Metals, 40 Grit, 3/4" Wide, 20-1/2" Long, Deliver To Eric L	30 Each	30
16	1505K94 Miniature Light Bulb Miniature-Bayonet Base, Push-In, Trade Number 1819, Packs of 10, Deliver To Luc	1 Pack	1
17	2757A22 Cutting Wheel for Tube and Pipe Cutter Ridgid 10, 15, and 20, for Tubing, Deliver To Luc	4 Each	4
18	8647A22 Mitutoyo Standard Electronic Caliper 500-197-30, 0-8" (0-200mm) Range, Deliver To Eric D	1 Each	1
19	5812A13 13 Piece Hex L-Key Set, Same As 7158A5 / Deliver To Jesse	2 Each	2
20	69485A21 9 Piece Metric Hex L-Key Set, Deliver To Jesse	2 Each	2

80174-27

DAS
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9-89

Shipped separately from our Chicago warehouse on 04/25

2	9776K131 1" Wide x 50' Long Loop, Adhesive Back, Beige	5 Each	5
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McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 25939851
Purchase Order: PO36069
Release:
McMaster-Carr Number: 2390118-04

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 25-Apr-2017 FOB: ORIGIN
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

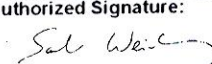
Billing
Attention:
Shipping
Attention:
Contact:

Line	Description	Qty & Unit	Unit Price	Extension
1	90130A030 Weather-Resistant EPDM Rubber Sealing Washer for 5/16" Screw Size, 0.29" ID, 0.562" OD, Packs of 100 Country of Origin: United States Schedule B #: 401693 ECCN #: EAR99 NLR	10 PK	\$10.81	\$108.10
4	95606A170 Nylon Plastic Washer for 7/16" Screw Size, 0.5" ID, 0.688" OD, Off-White, Packs of 100 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$8.60	\$8.60
5	93695K58 Oil-Resistant Fire-Retardant Blended Buna-N Foam 50 Feet Adhesive-Back Strip, 1/4" Thick, 1" Wide Country of Origin: United States Schedule B #: 400811 ECCN #: EAR99 NLR	1 EA	\$16.15	\$16.15
6	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End 3/8"-24 RH Male Shank, 3/8" Ball ID, 1-1/4" Long Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	15 EA	\$19.05	\$285.75

SP 17-4-27

DAS
38
7-89

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

Shipping Weight (in kgs): 7	Number of Packages: 1	Invoice Amounts:	Merchandise Amount: \$1,020.99 Canadian GST/HST: \$135.04 Shipping Charges: \$17.66 Total (In USD): \$1,173.69
Package Dimensions: 44 X 44 X 32 CM = .063 CUBIC M		Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days	
Authorized Signature: 	Date: 25-Apr-2017	Remit payment to: (by wire transfer) Bank of America 222 Broadway New York, NY 10038 Account 86666-02021 SWIFT BOFAUS3N (by mail) McMaster-Carr Supply Company PO Box 7690 Chicago, IL 60680-7690 USA	
Name: Sarah Weinberg	Title: Operations Mgr.	Page 1 of 3	